

Date: Thursday, 3/16/2006 10:37:07 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHROUD ASSEMBLY
Job Number : 26261	
Estimate Number : 12301	
P.O. Number : N/A	Part Number : D3467047
This Issue : 3/16/2006 S.O. No. : N/A	Drawing Number : D3467 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL / MED FAB	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <u>See Comment Below</u>	Due Date : 3/31/2006 Qty: 1 Um: Each
Checked & Approved By : <u>06-03-16</u>	
Comment : Est Rev: A New Issue 06-03-01 EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D34671	COVER PLATE LH
-----	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D3467-1	Shourd Plate	
---	---------	--------------	--

Fabricate by hand as  
per dwg D3467-1

06-03-30 ①

M19704 (M304526GA) 14"x8"

2.0	D34677	SEAL STRIP
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D3467-7	Doubler	
---	---------	---------	--

Fabricate by hand as  
per dwg D3467-7

06-03-30 ①

M19704 (M304526GA) 6"x1.5"

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3467

2-Spot Weld as per Dwg D3467 and Dart QSI 004

3-Identify as D3467-047

06-03-30 ①

4.0	QC5/9	WELD INSPECTION
-----	-------	-----------------



Comment: WELD INSPECTION

06-03-30 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/03/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/16/2006 10:37:07 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD ASSEMBLY

Job Number: 26261

Part Number: D3467047

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: \_\_\_\_\_

Electro Chemically Polish weldment as per Dwg D3467

Ensure Certificate of Conformity is attached

Identify as D3467-047

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT

1-Inspect finish

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



u 06.03.30

06.03.30 ①

06.03.31 ①

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

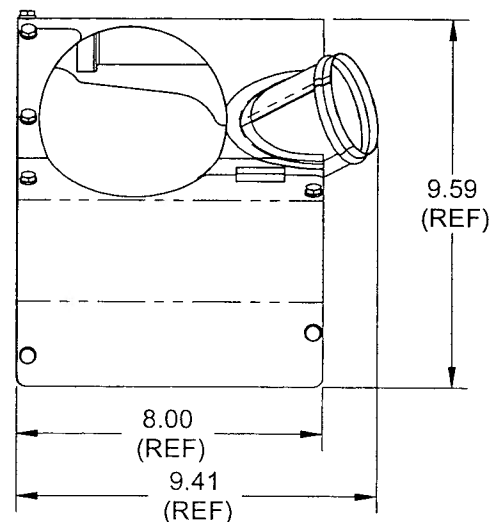
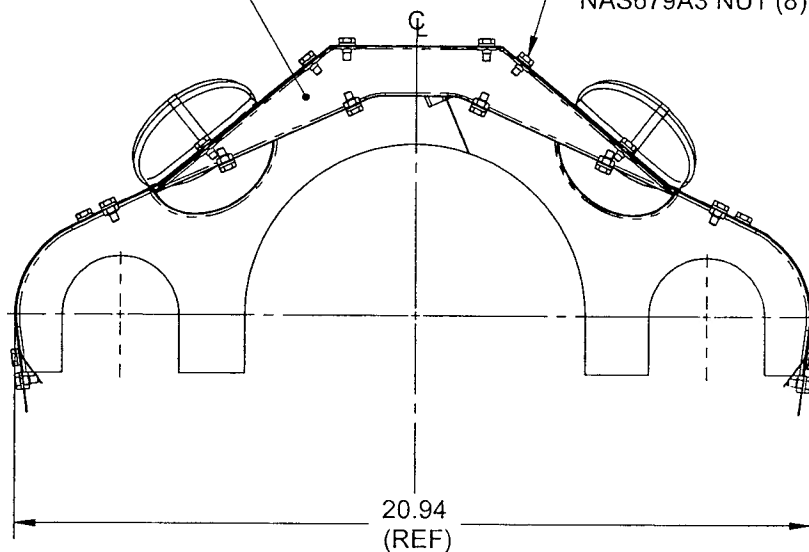
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PRELIMINARY ISSUE

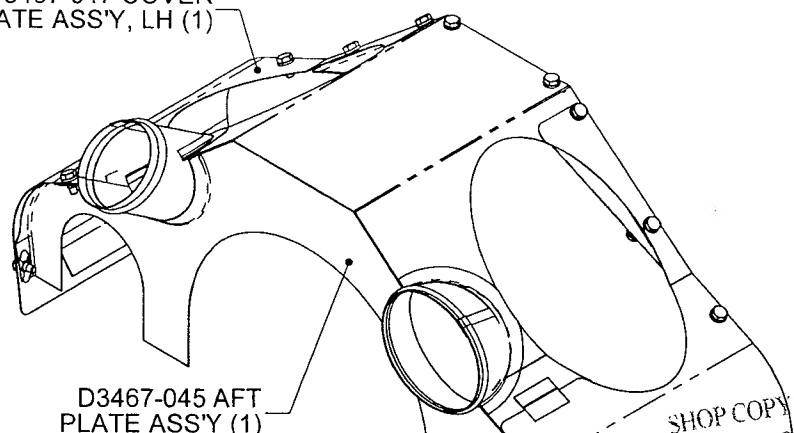
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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:5
A	05.12.07	NEW ISSUE	

D3467-043 FWD  
PLATE ASS'Y (1)

AN3-3A BOLT (18)  
AN960-10 WASHER (18)  
NAS679A3 NUT (8)



D3467-047 COVER  
PLATE ASS'Y, LH (1)



D3467-045 AFT  
PLATE ASS'Y (1)

D3467-048 COVER  
PLATE ASS'Y, RH (1)

### D3467-041 SHROUD ASSEMBLY

#### NOTES:

- 1) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

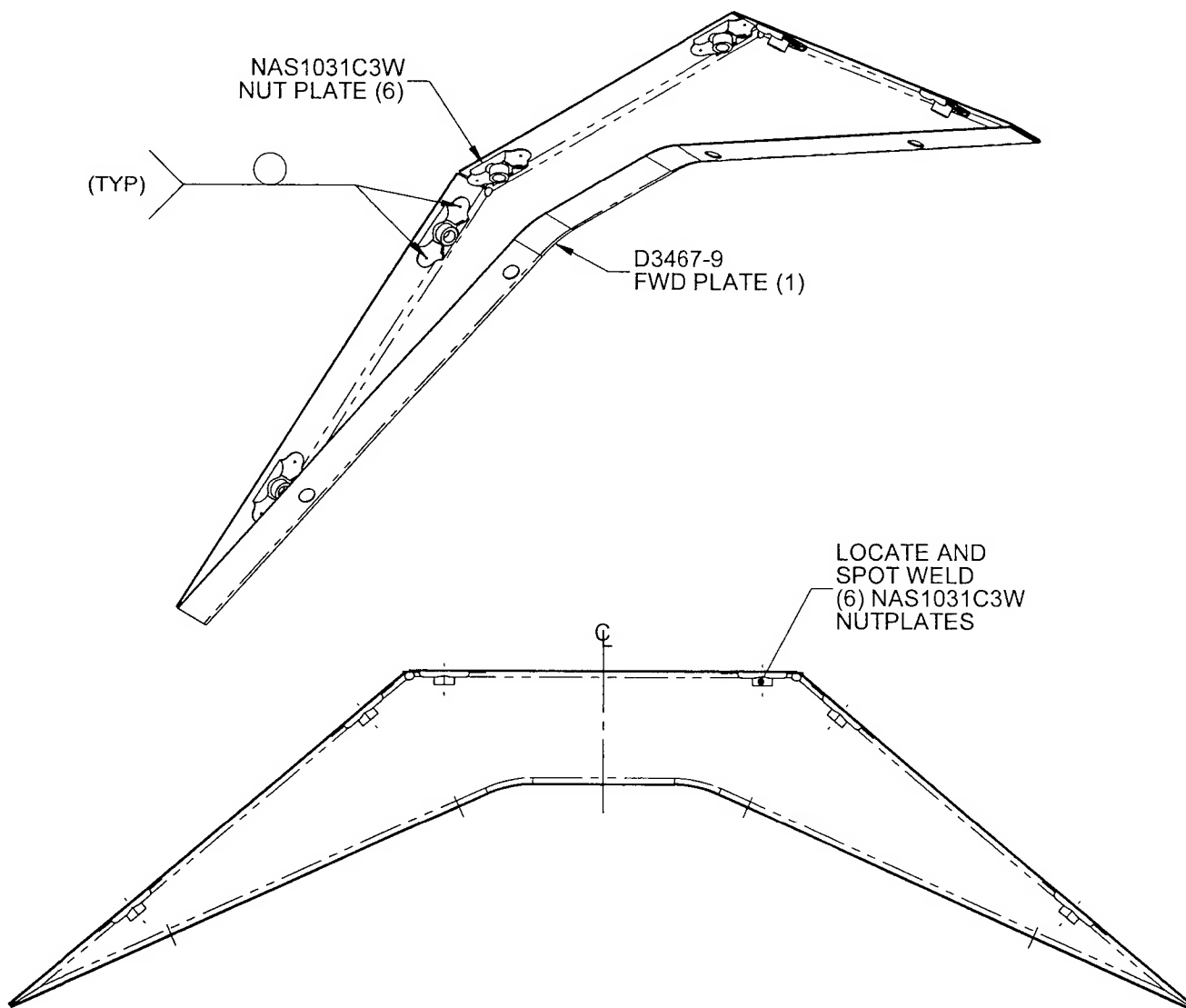
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DATE <b>05.12.07</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:2



**D3467-043 FWD PLATE ASSEMBLY**

**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) ASSEMBLY IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: ELECTRO CHEMICALLY POLISH
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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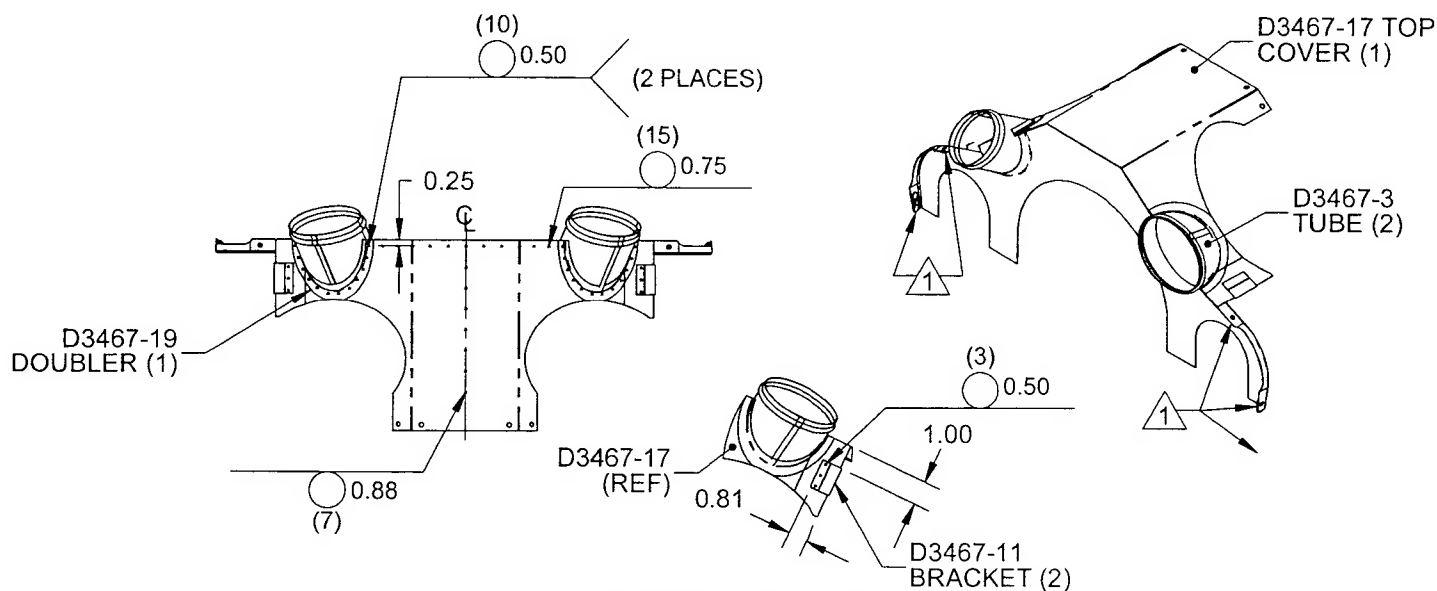
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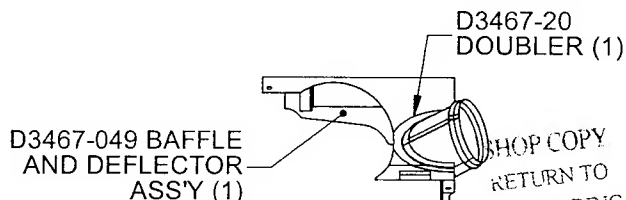
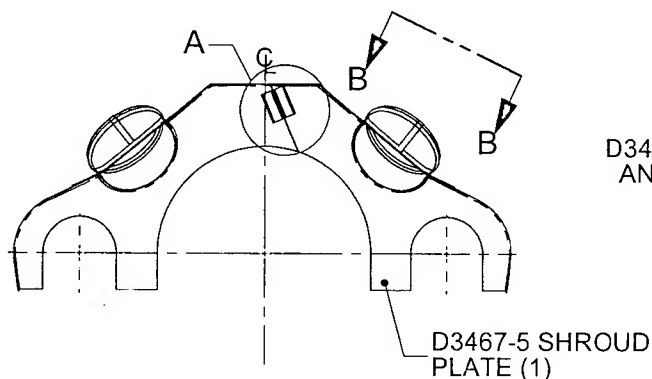


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DATE <b>05.12.07</b>	TITLE <b>SHROUD ASSEMBLY</b>		SCALE 1:8



**VIEW B-B: WELDING D3467-11**  
D3467-047 NOT SHOWN FOR CLARITY  
(2 PLACES)



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### **D3467-045 AFT PLATE ASSEMBLY**

#### **NOTES:**

- 1) LOCATE AND SPOT WELD NAS1031CW NUTPLATE (4) TO D3467-5 PRIOR WELDING OTHER PARTS TO D3467-5
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: ELECTRO-CHEMICALLY POLISH
- 4) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

**DETAIL A**  
SCALE 1:2

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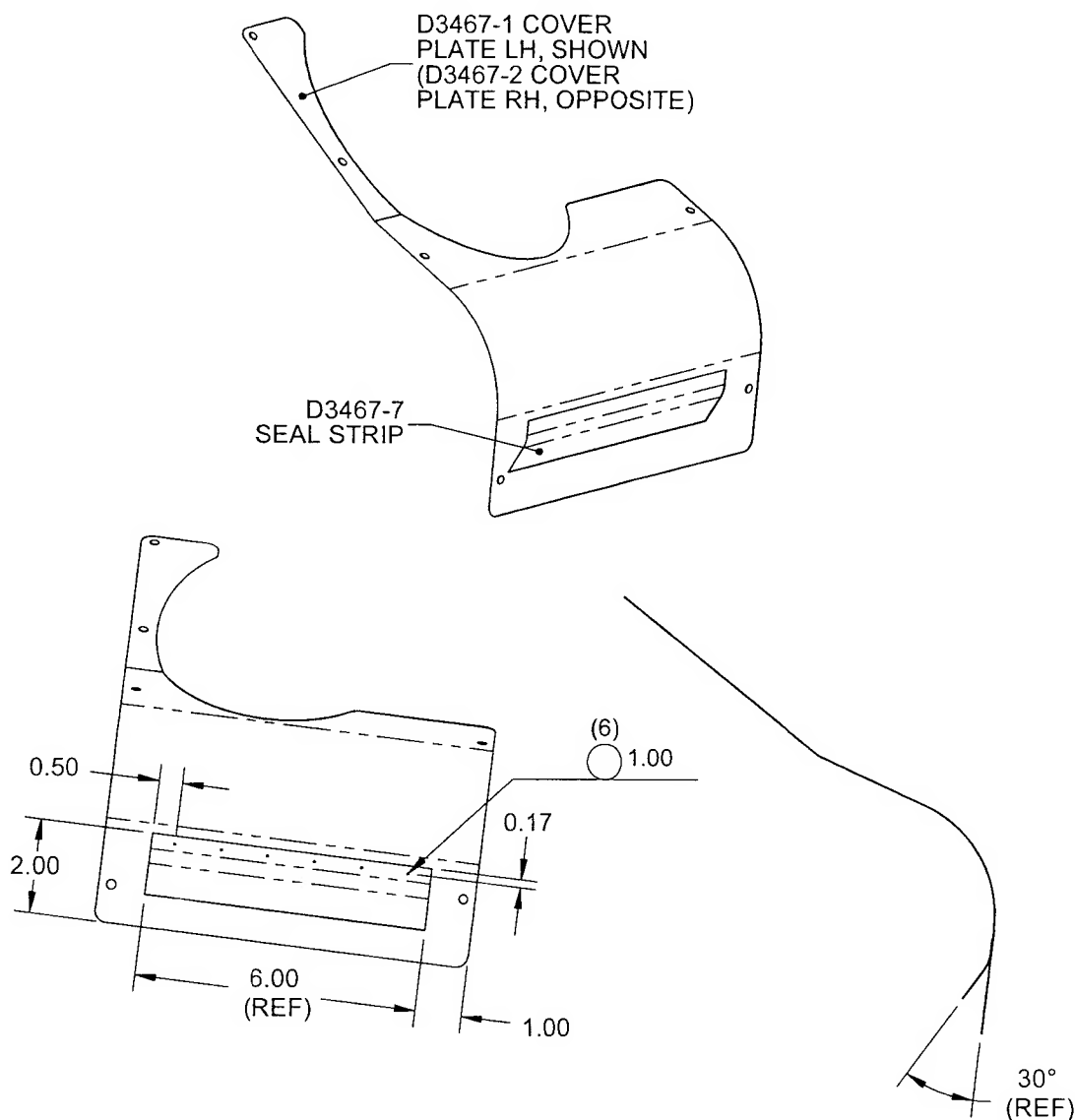
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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:4



**D3467-047 COVER PLATE ASS'Y LH, SHOWN**  
**D3467-048 COVER PLATE ASS'Y RH, OPPOSITE**

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: ELECTRO CHEMICALLY POLISHED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

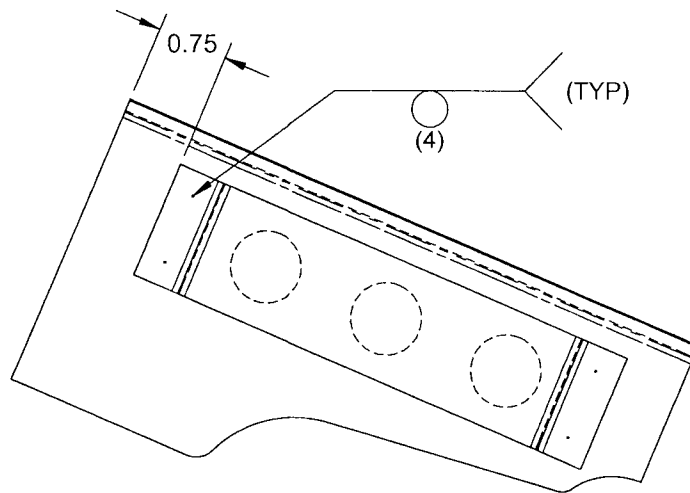
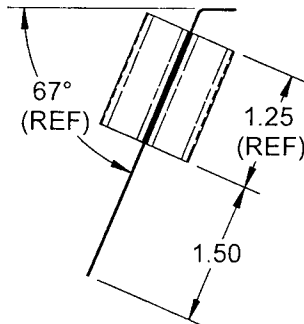
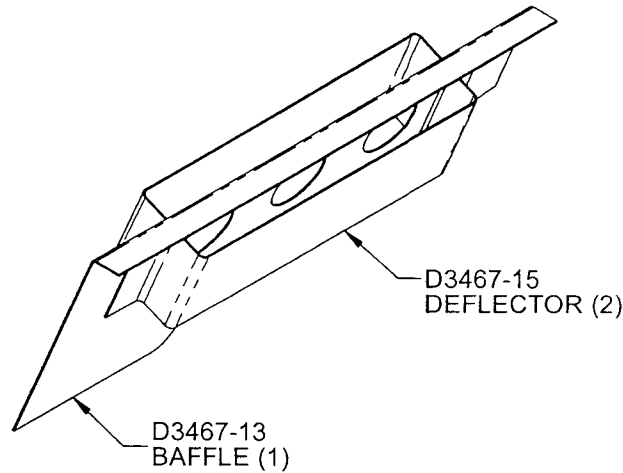
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### D3467-049 BAFFLE & DEFLECTOR ASSEMBLY

#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

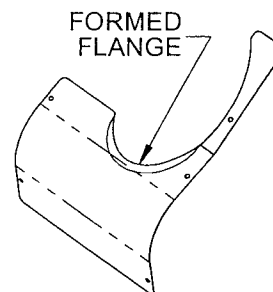
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THIRTEEN



**D3467-1 LH COVER  
PLATE ISOMETRIC VIEW,  
D3467-2 RH COVER  
PLATE (OPPOSITE)  
SCALE 1:8**

1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)

2) FINISH: ELECTRO CHEMICALLY POLISH

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

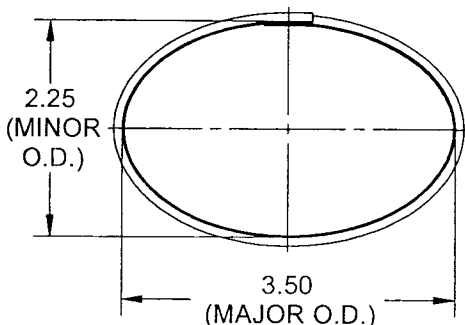
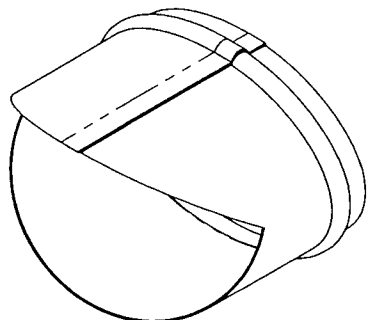
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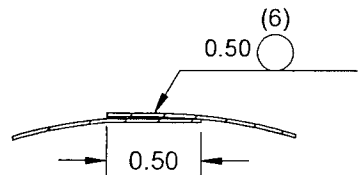
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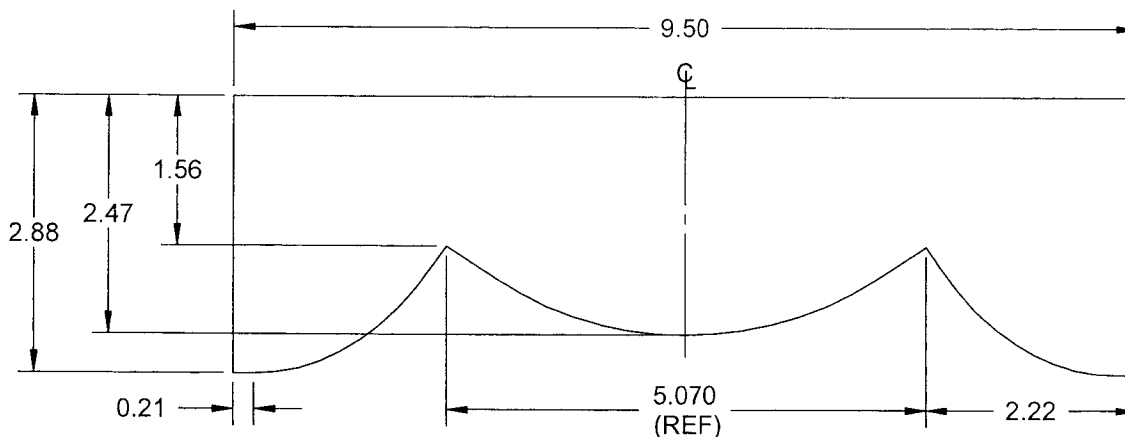
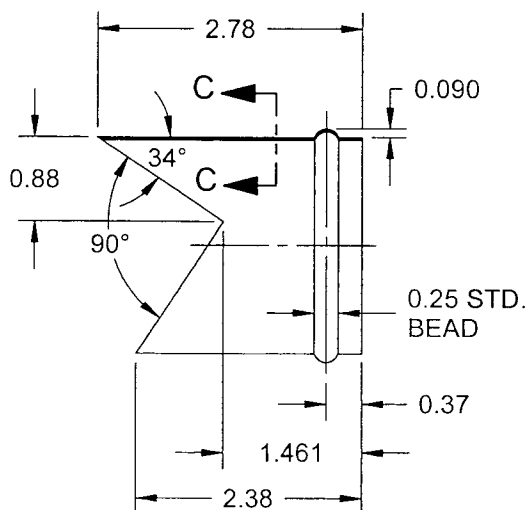
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DATE <b>05.12.07</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:2



**D3467-3 TUBE DETAIL**



**SECTION C-C**  
SCALE 1:1



**D3467-3F TUBE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) SPOT WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

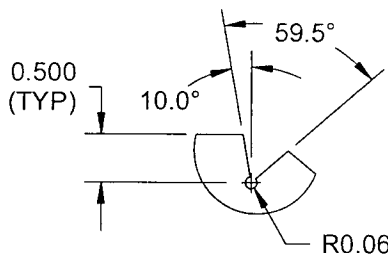
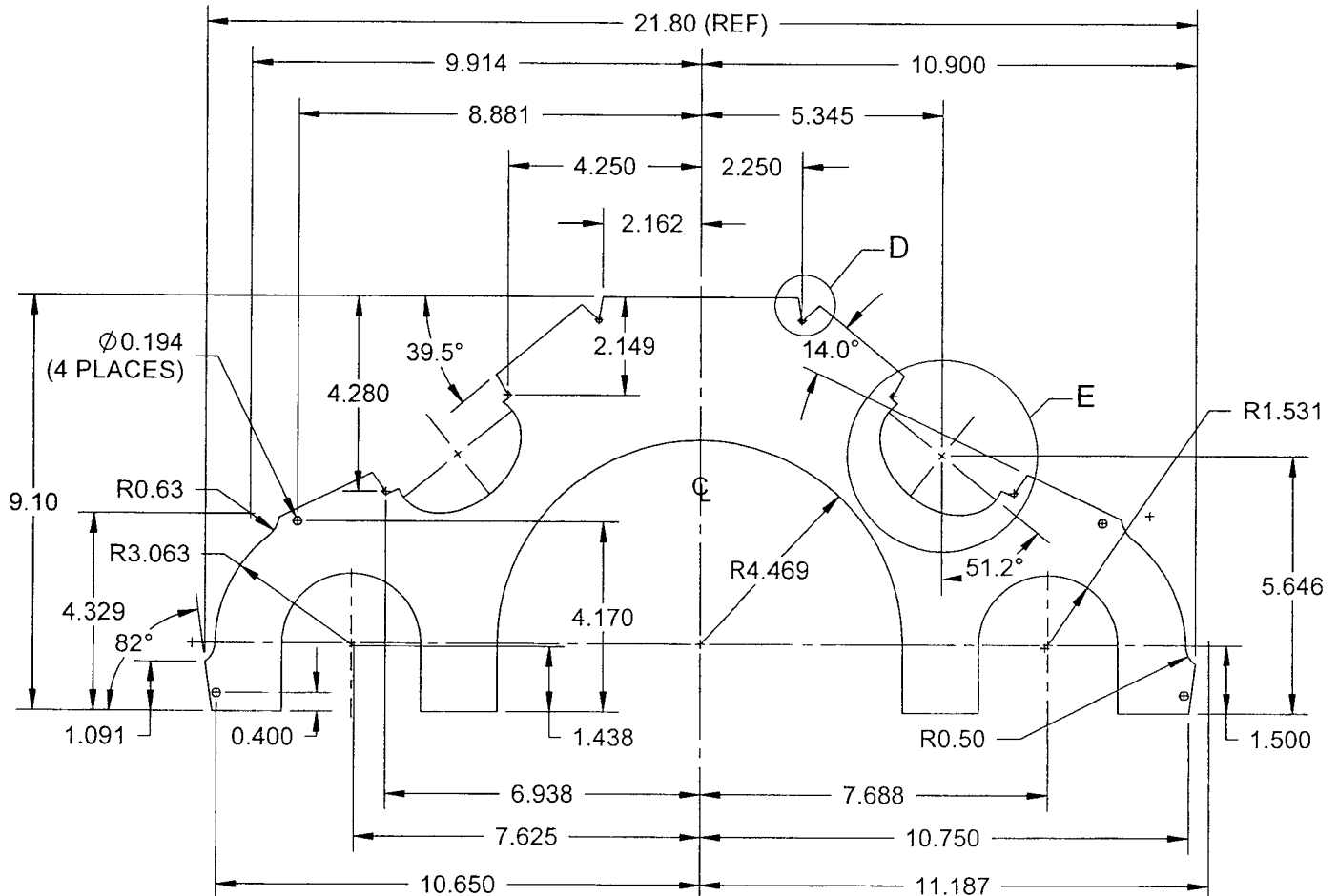
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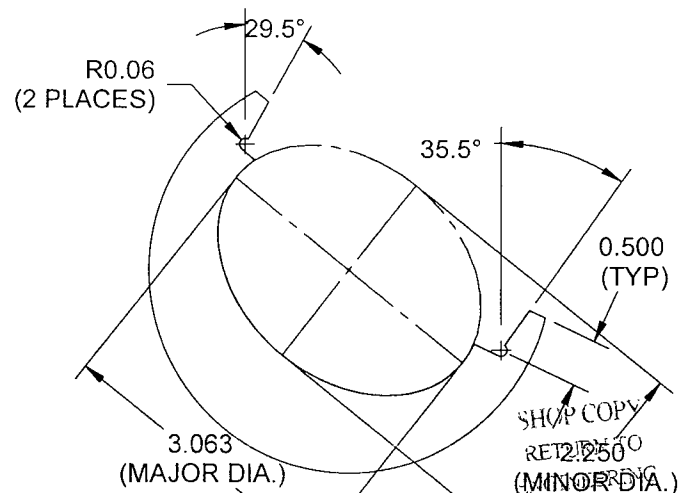
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DATE <b>05.12.07</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:8



**DETAIL D**  
SCALE 1:2



**DETAIL E**  
SCALE 1:2

### D3467-5F AFT PLATE FLAT PATTERN

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019  
(ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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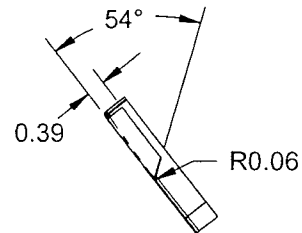
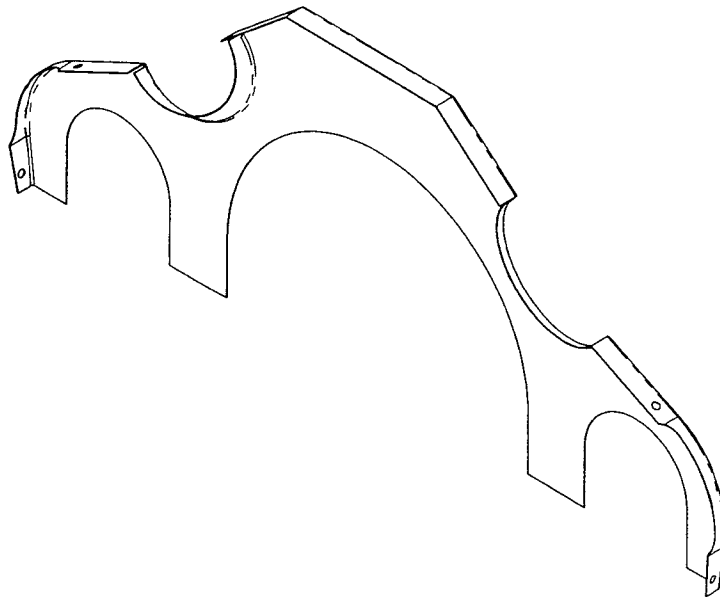
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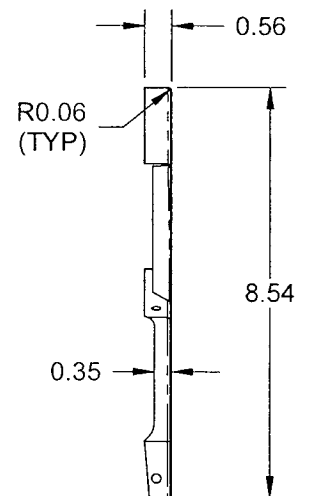
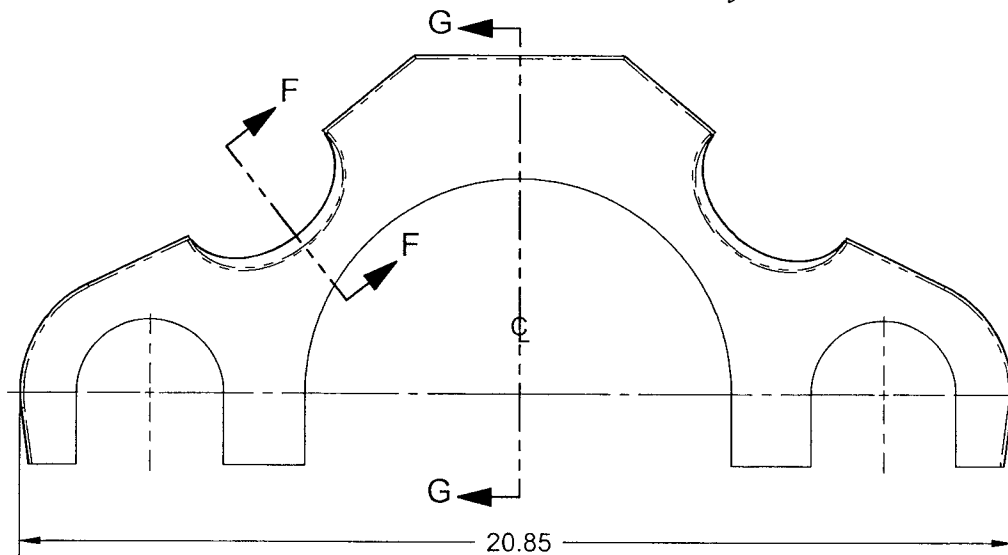


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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:4



**SECTION F-F**



**SECTION G-G**

**D3467-5 AFT PLATE BENDING DETAIL**

**NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

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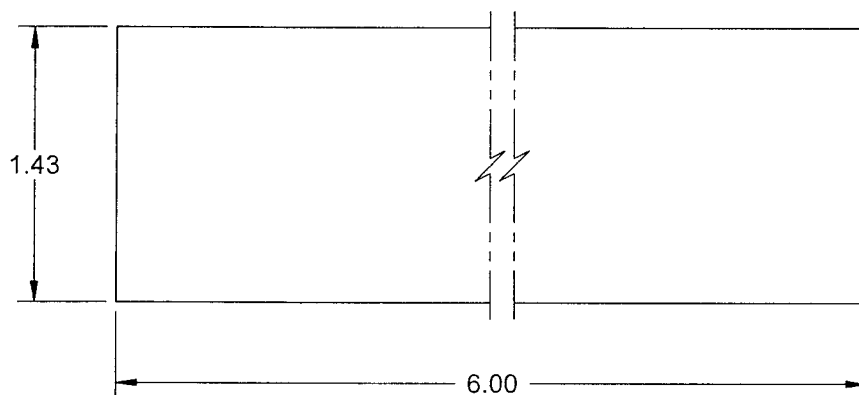
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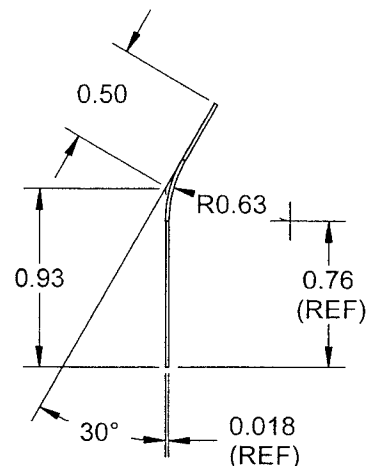


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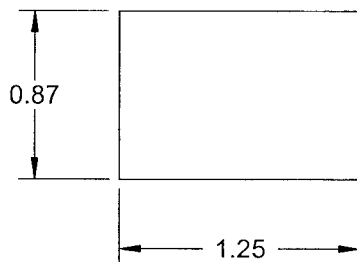
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DATE <b>05.12.07</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:1



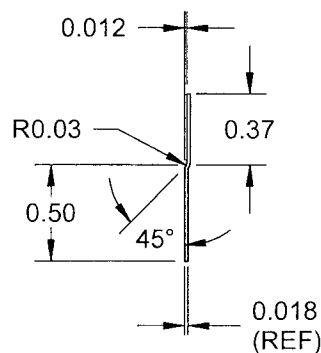
**D3467-7F SEAL STRIP**  
**FLAT PATTERN**



**D3467-7 SEAL STRIP**  
**BENDING DETAIL**



**D3467-11F BRACKET**  
**FLAT PATTERN**



**D3467-11 BRACKET**  
**JOGGLE DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

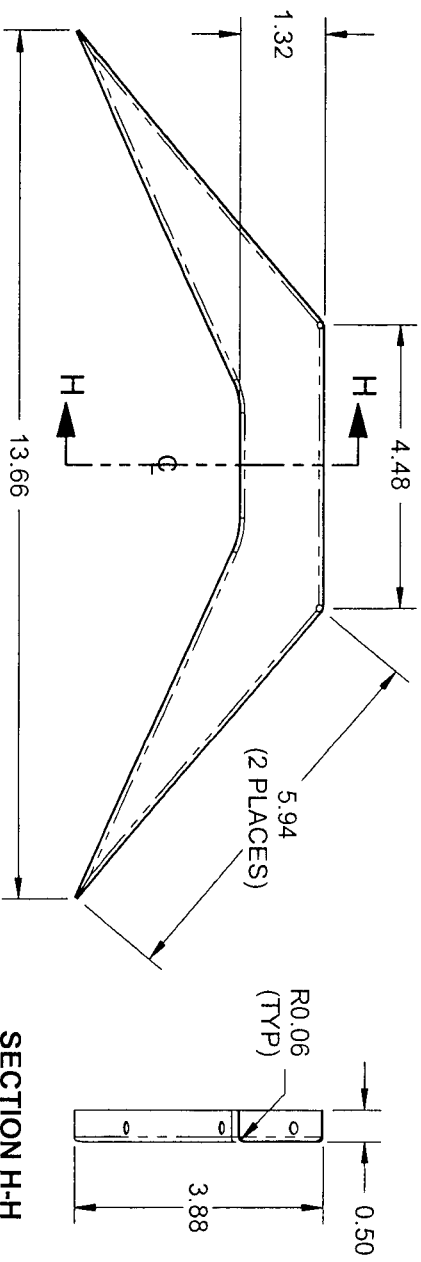
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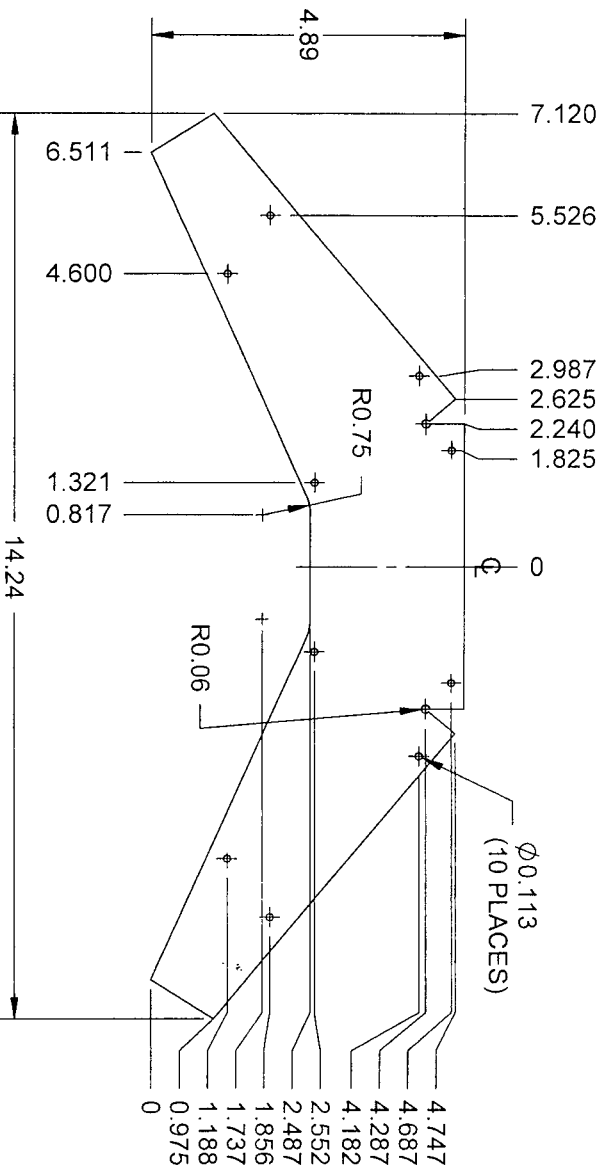
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# PRELIMINARY ISSUE

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3467</b>
DATE 05.12.07	TITLE SHROUD ASSEMBLY	REV. A SHEET 11 OF 15
	SCALE 1:3	



**D3467-9 FWD PLATE BENDING DETAIL**



**D3467-9F FWD PLATE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) ~~26 GAUGE~~ 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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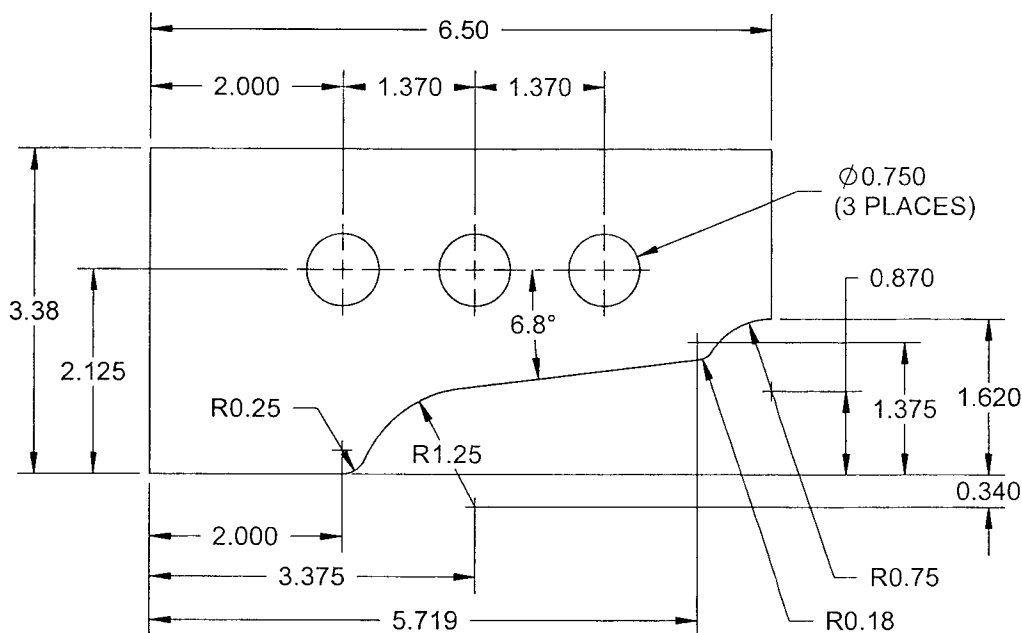
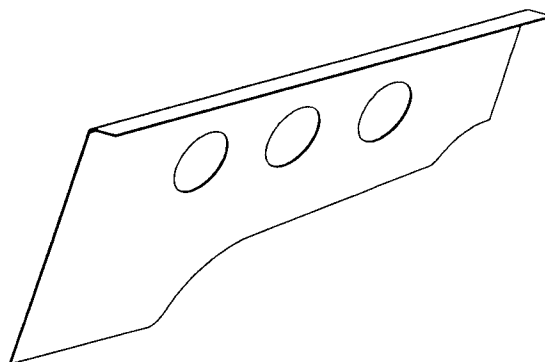
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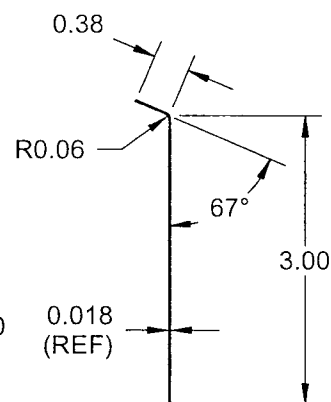
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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:2



**D3467-13F BAFFLE  
FLAT PATTERN**



**D3467-13 BAFFLE  
BEND DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

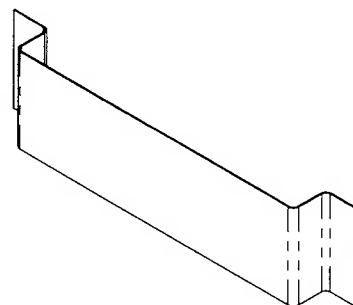
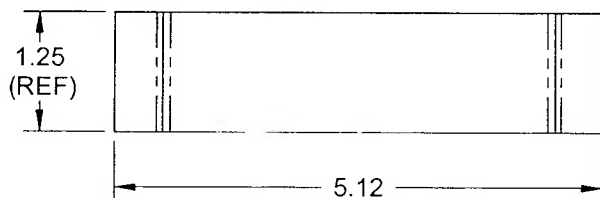
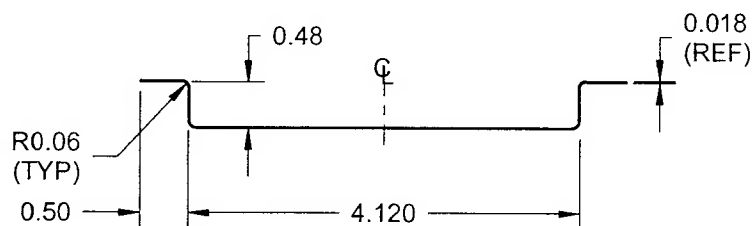
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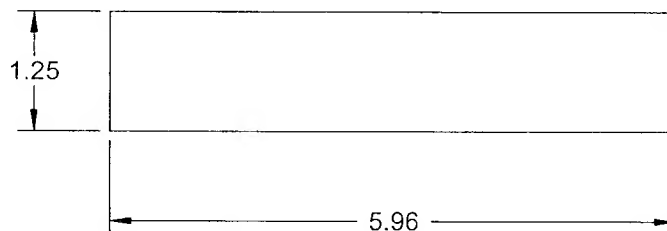
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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:2



### D3467-15 DEFLECTOR BENDING DETAIL



### D3467-15F DEFLECTOR FLAT PATTERN

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

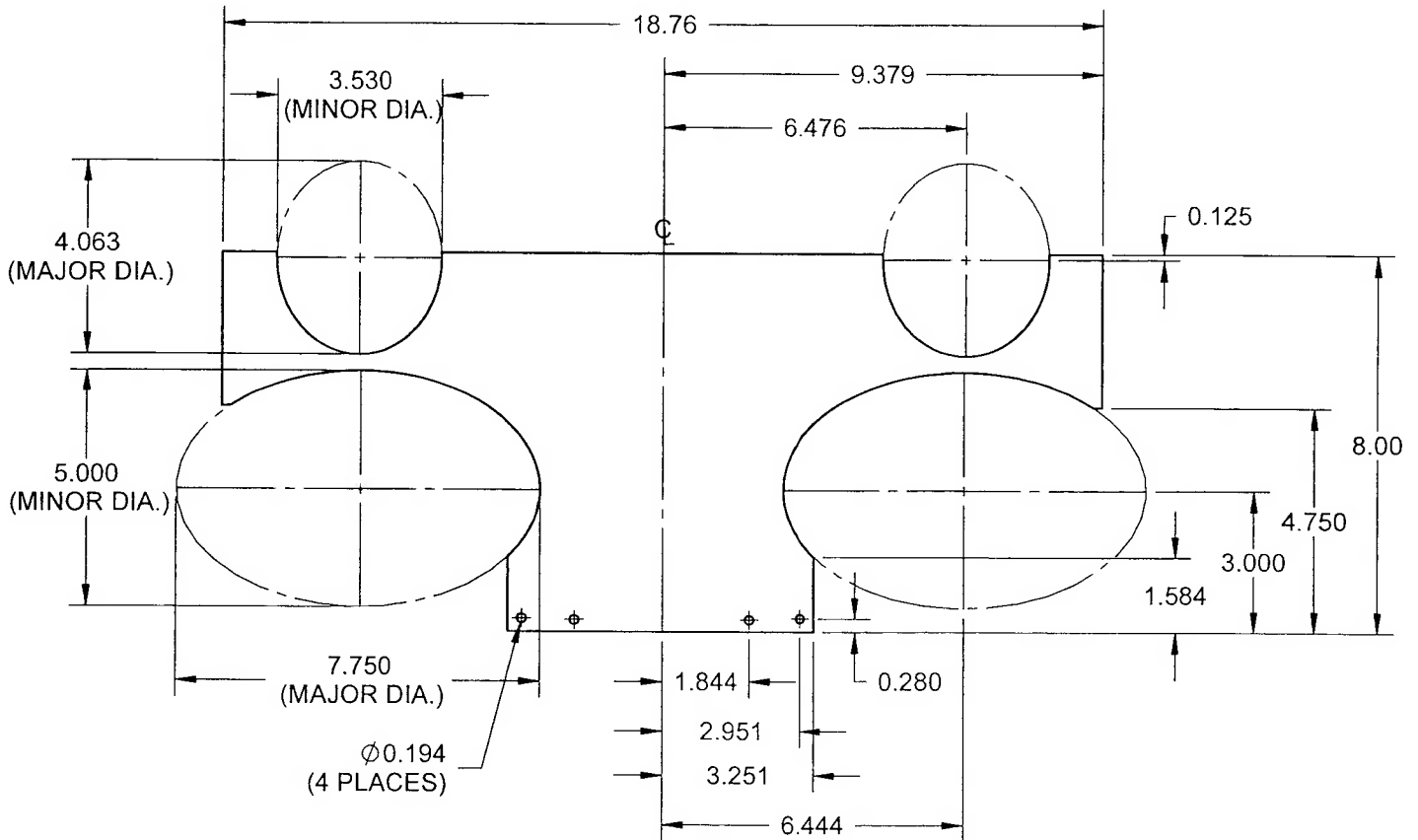
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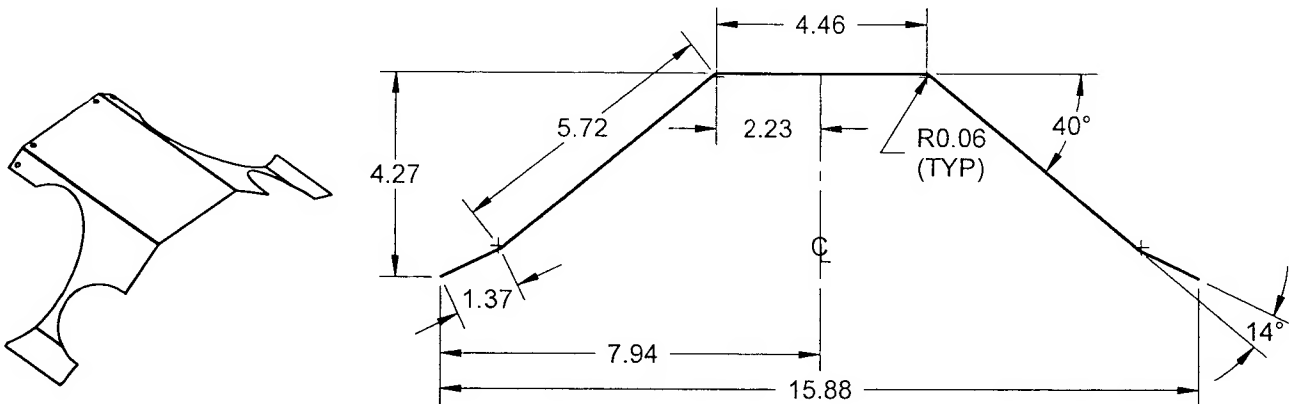
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DATE <b>05.12.07</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:4



**D3467-17F TOP COVER FLAT PATTERN**



**D3467-17 TOP COVER BENDING DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

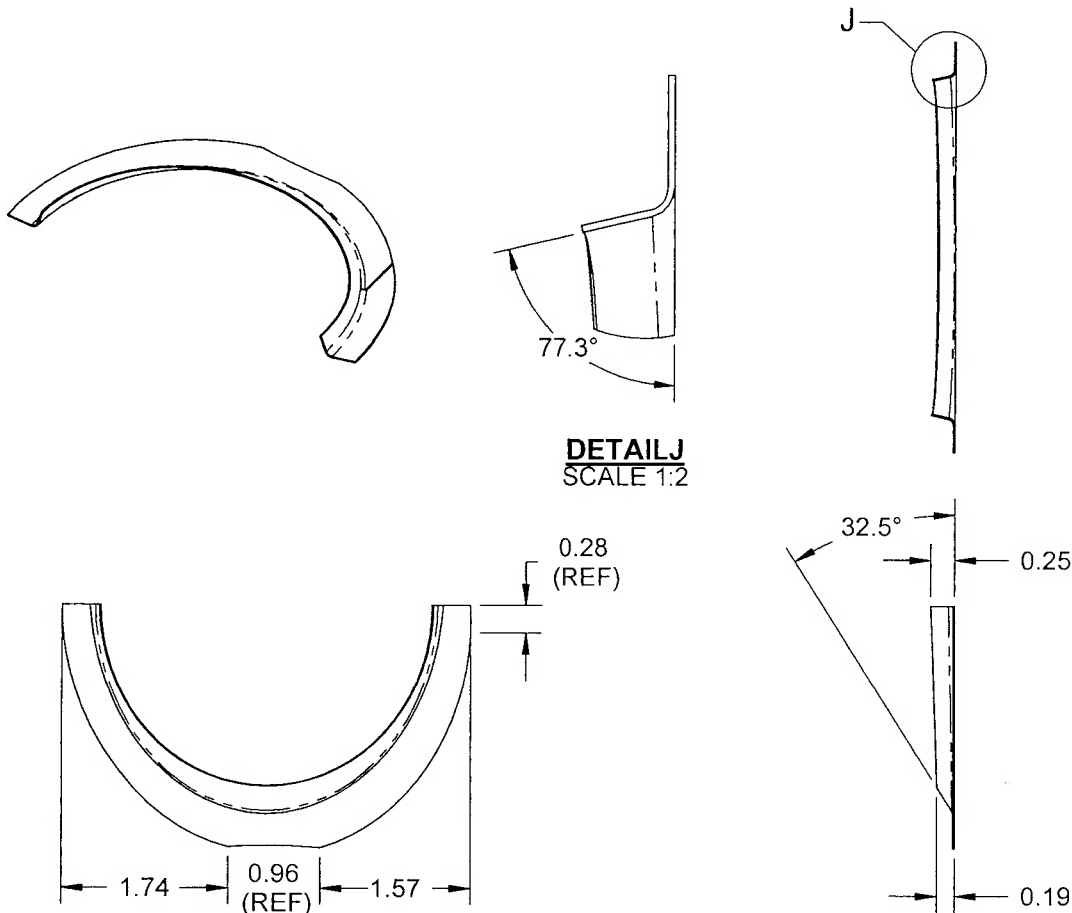
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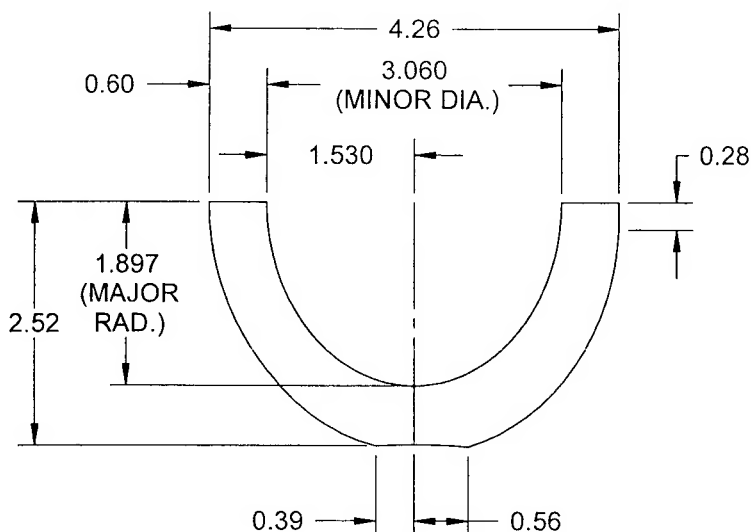
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DATE <b>05.12.07</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:2



**D3467-19 DOUBLER, LH SHOWN**  
**D3467-20 DOUBLER, RH OPPOSITE**



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**D3467-19F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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